

Date: Thursday, 9/14/2006 7:31:07 AM  
 User: Kim Johnston

## Process Sheet

|   |                                      |
|---|--------------------------------------|
| Customer : CU-DAR001 Dart Helicopters Services                                    | Drawing Name : BAFFLE                |
| Job Number : 28591  |                                      |
| Estimate Number : 12216   |                                      |
| P.O. Number : <u>NIA</u>  | Part Number : D346713                |
| This Issue : 9/14/2006 S.O. No. : <u>NIA</u>                                      | Drawing Number : D3467 REV.B         |
| Prsht Rev. : NC   | Project Number : N/A                 |
| First Issue : <u>NIA</u> Type : SMALL / MED FAB                                   | Drawing Revision : B                 |
| Previous Run : 27010  | Material : <u>NIA</u>                |
| Written By : _____  | Due Date : 10/6/2006 Qty: 4 Um: Each |
| Checked & Approved By : <u>060914</u>   |                                      |
| Comment : est rev. A 06.04.20 new issue EC<br>Est Rev:B As per Rev B 06-05-24 JLM |                                      |

## Additional Product

Job Number:



| Seq. #: | Machine Or Operation: | Description : |
|---------|-----------------------|---------------|
|---------|-----------------------|---------------|

|     |           |                     |
|-----|-----------|---------------------|
| 1.0 | M304S26GA | 304/316 0.018 SHEET |
|-----|-----------|---------------------|



Comment: Qty.: 0.1575 sf(s)/Unit Total : 0.6300 sf(s)  
 304/316 0.018 SHEET batch: M101000

|     |           |                |
|-----|-----------|----------------|
| 2.0 | WATER JET | FLOW WATER JET |
|-----|-----------|----------------|



Comment: FLOW WATER JET  
 Cut as per Dwg D3467  
 Dwg Rev: B  
 Prog Rev: B

SAD 06:09:23 (4)

|     |     |  |
|-----|-----|--|
| 3.0 | QC2 | INSPECT PARTS AS THEY COME OFF MACHINE |
|-----|-----|--|



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

SAD 06:09:23 (4)

|     |     |              |
|-----|-----|--------------|
| 4.0 | QC8 | SECOND CHECK |
|-----|-----|--------------|



Comment: SECOND CHECK

060925 (4)

|     |             |                               |
|-----|-------------|-------------------------------|
| 5.0 | SMALL FAB 1 | SMALL & MEDIUM FAB RESOURCE 1 |
|-----|-------------|-------------------------------|



Comment: SMALL & MEDIUM FAB RESOURCE 1  
 1-Debur

2-Bend as per dwg D3467

MF 06/09/26 (4)

SB 06/09/27

**Dart Aerospace Ltd**

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: ☒ Date: 06/09/08  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

**NOTE:** Date & initial all entries

Date: Thursday, 9/14/2006 7:31:07 AM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BAFFLE

Job Number: 28591

Part Number: D346713

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



*Job 28-28 (4)*



Comment: INSPECT WORK TO CURRENT STEP

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *31439*

*B 06/09/28 (4)*

8.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

*06/09/28 (4)*

Job Completion



*W 06-09-28*

**Dart Aerospace Ltd**

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

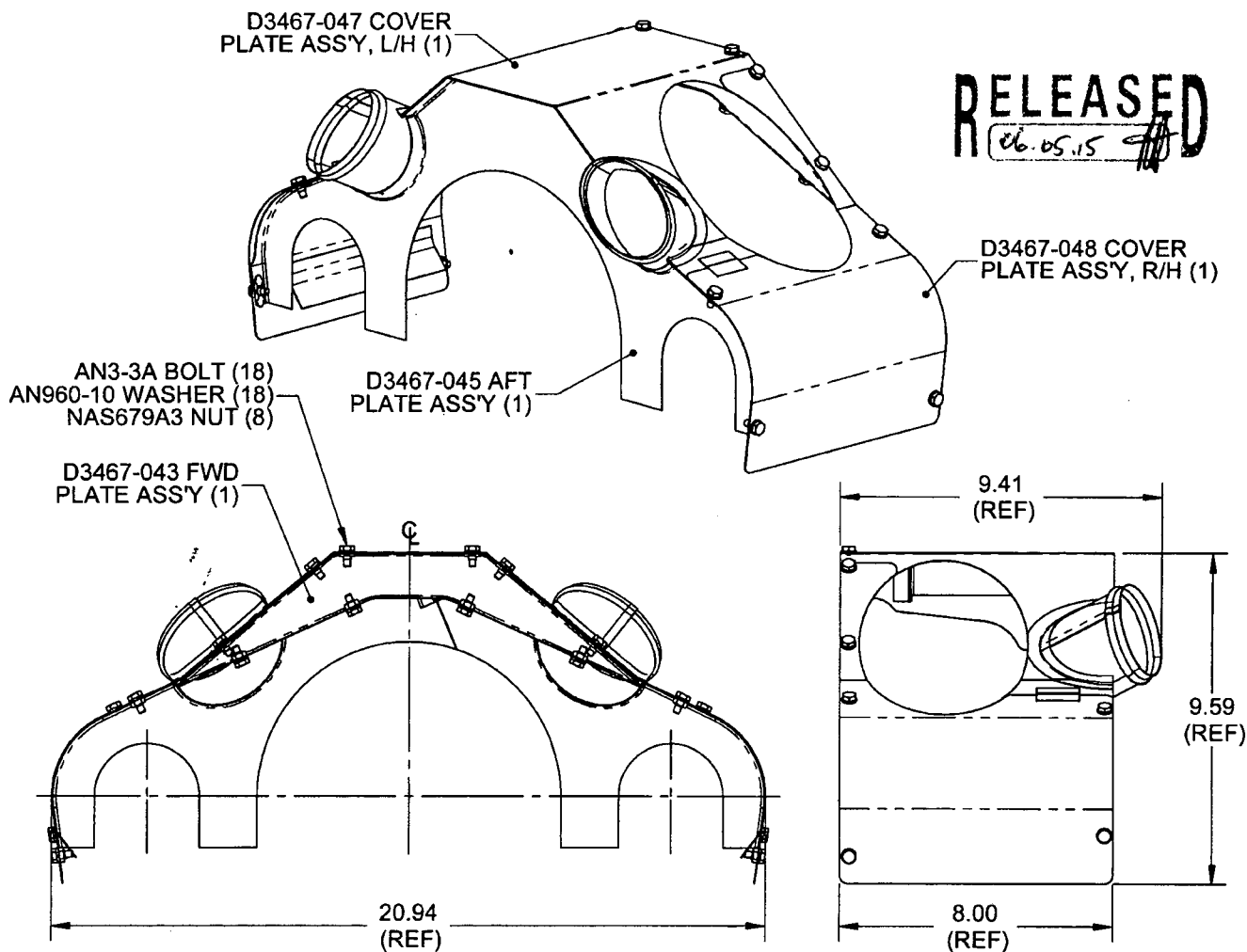
QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

**NOTE:** Date & initial all entries



|                  |               |  |                         |
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| DESIGN<br>B      | DRAWN BY<br>B | DART AEROSPACE LTD<br>HAWKESBURY, ONTARIO, CANADA      |                         |
| CHECKED<br>H     | APPROVED<br>H | DRAWING NO.<br>D3467                                   | REV. B<br>SHEET 1 OF 15 |
| DATE<br>06.05.15 |               | TITLE<br>SHROUD ASSEMBLY<br>SCALE<br>1:5               |                         |
| A                | 05.12.07      | NEW ISSUE  |                         |
| B                | 06.05.15      | Ø0.250 & Ø0.203 WERE Ø0.194 ;<br>UPDATED D3467-9F/-15F |                         |



### D3467-041 SHROUD ASSEMBLY

#### NOTES:

- 1) IDENTIFY WITH DART P/N D3467-041 USING FINE POINT PERMANENT INK MARKER
- 2) ASSEMBLY IS SYMMETRICAL ABOUT CENTERLINE
- 3) FINISH: NONE
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010

| QTY<br>-041 | P/N       | DESCRIPTION               |
|-------------|-----------|---------------------------|
| X           | D3467-041 | SHROUD ASSEMBLY           |
| 1           | D3467-043 | FWD PLATE ASSEMBLY        |
| 1           | D3467-045 | AFT PLATE ASSEMBLY        |
| 1           | D3467-047 | COVER PLATE ASSEMBLY, L/H |
| 1           | D3467-048 | COVER PLATE ASSEMBLY, R/H |
| 18          | AN3-3A    | BOLT                      |
| 18          | AN960-10  | WASHER                    |
| 8           | NAS679A3  | NUT                       |

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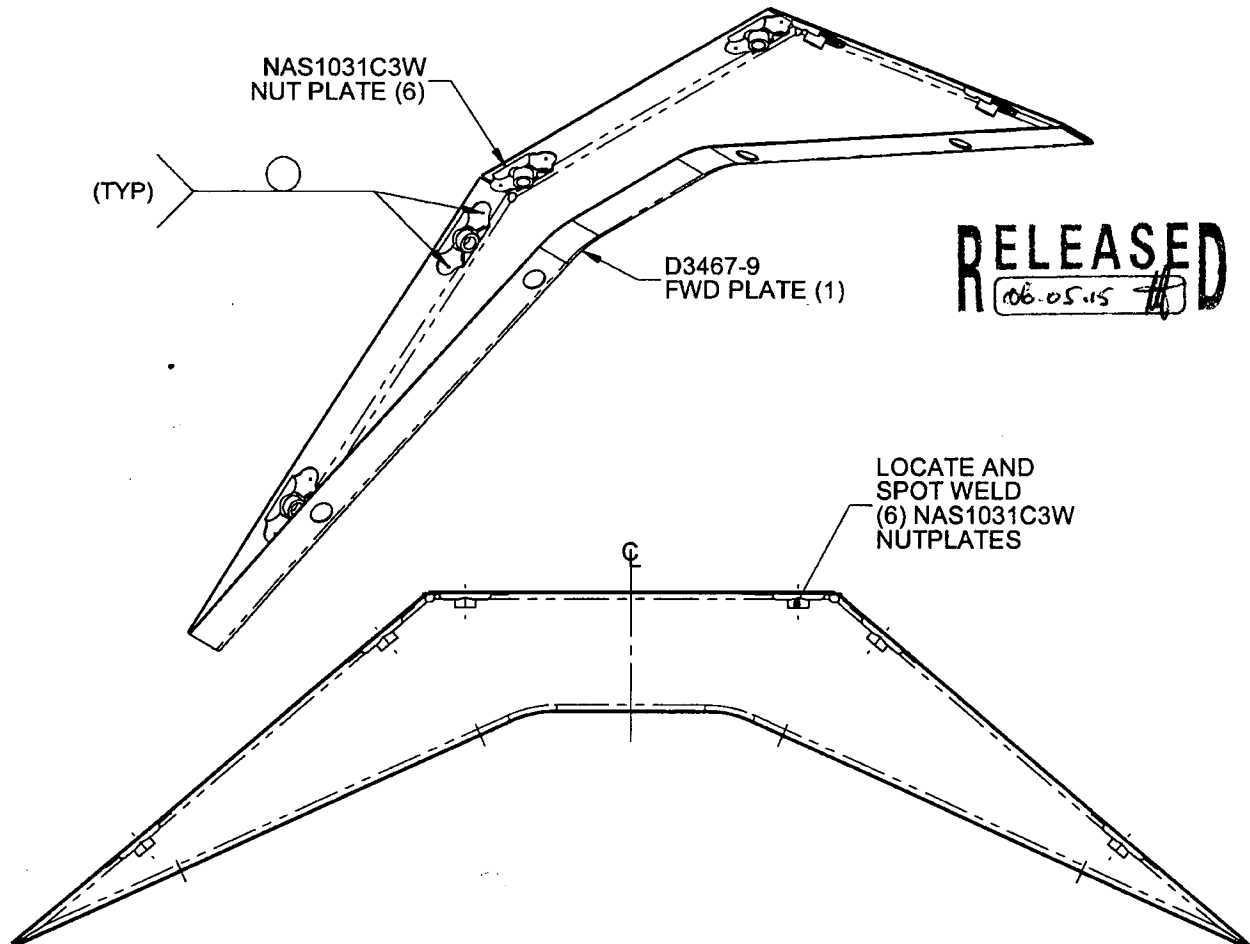
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| DATE<br><b>06.05.15</b> |               | TITLE<br><b>SHROUD ASSEMBLY</b>                          | SCALE<br>1:2            |



| QTY<br>-043 | P/N        | DESCRIPTION        |
|-------------|------------|--------------------|
| X           | D3467-043  | FWD PLATE ASSEMBLY |
| 1           | D3467-9    | FWD PLATE          |
| 6           | NAS1031C3W | NUT PLATE          |

### D3467-043 FWD PLATE ASSEMBLY

#### NOTES:

- 1) SPOT WELD PER DART QSI 004
- 2) FINISH: NONE
- 3) ASSEMBLY IS SYMMETRICAL ABOUT CENTER LINE
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010

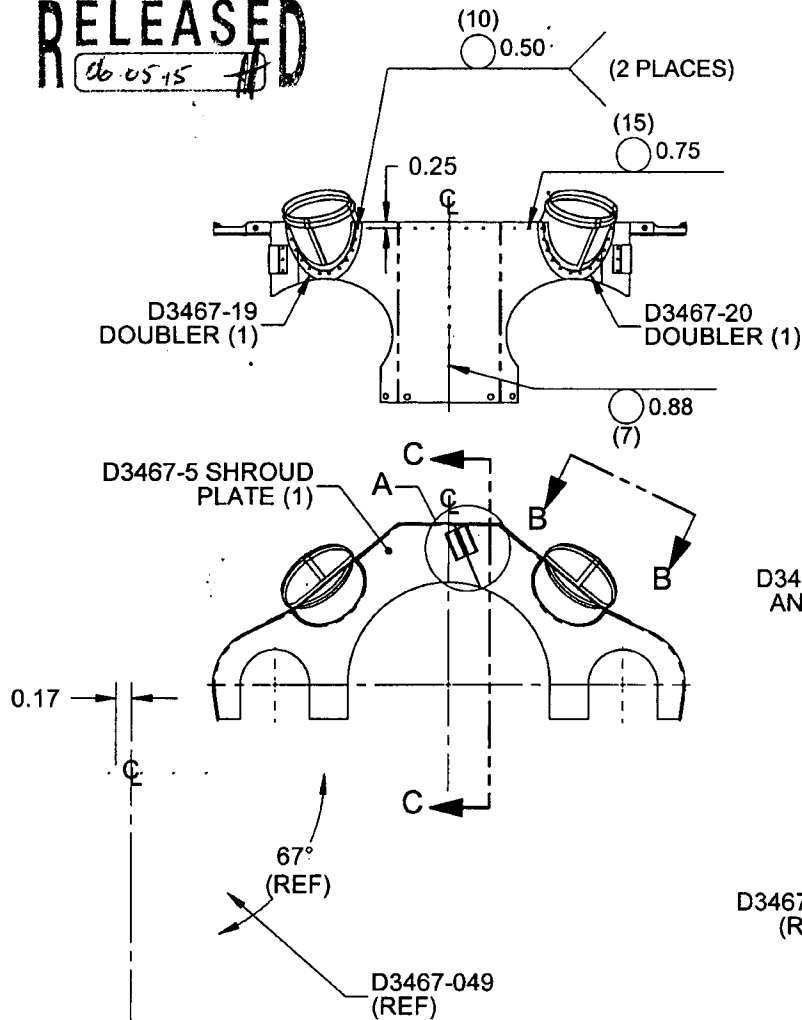
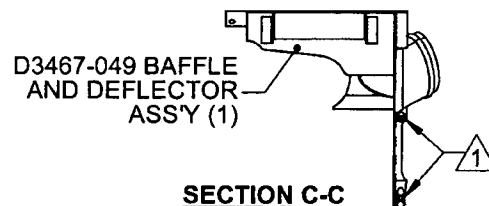
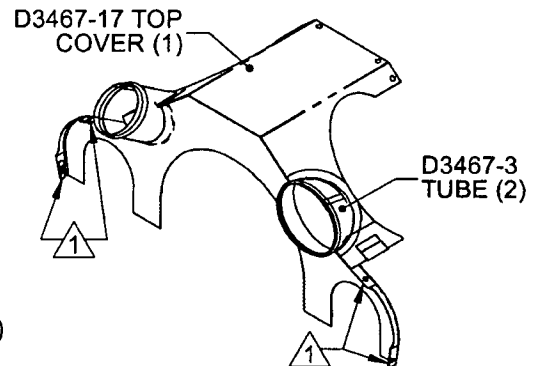
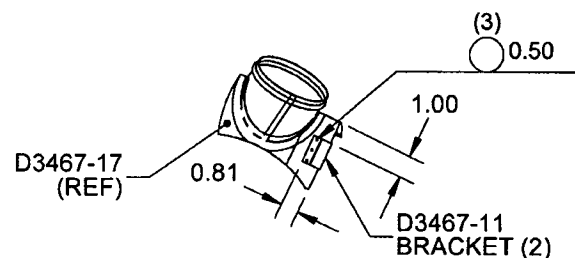
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| DATE<br><b>06.05.15</b> |                | TITLE<br><b>SHROUD ASSEMBLY</b>                          | SCALE<br>1:8            |

**RELEASED**  
06.05.15**DETAIL A**  
SCALE 1:2**SECTION C-C****VIEW B-B: WELDING D3467-11**  
D3467-047 NOT SHOWN FOR CLARITY  
(2 PLACES)**D3467-045 AFT PLATE ASSEMBLY****NOTES:**

- 1) LOCATE AND SPOT WELD NAS1031C3W NUTPLATE (4) TO D3467-5 PRIOR WELDING OTHER PARTS TO D3467-5
- 2) SPOT WELD PER DART QSI 004
- 3) FINISH: NONE
- 4) ASSEMBLY IS SYMMETRICAL ABOUT CENTERLINE
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES
- 7) BREAK ALL SHARP EDGES 0.005 TO 0.010

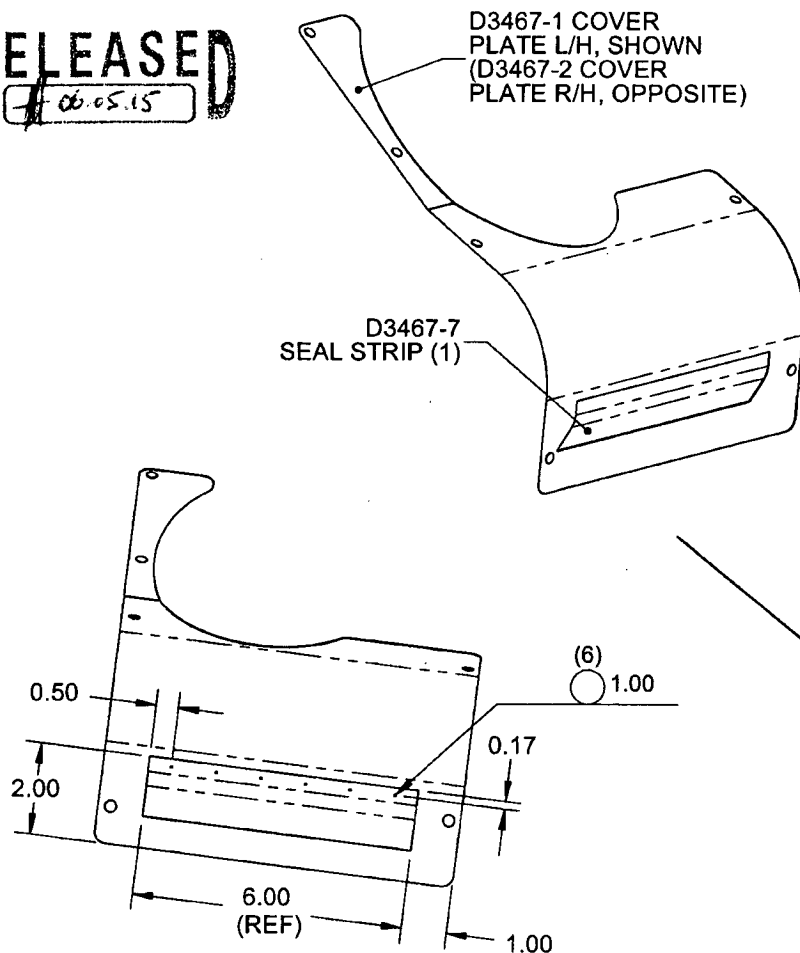
| QTY<br>-045 | P/N        | DESCRIPTION                   |
|-------------|------------|-------------------------------|
| X           | D3467-045  | AFT PLATE ASSEMBLY            |
| 1           | D3467-049  | BAFFLE AND DEFLECTOR ASSEMBLY |
| 2           | D3467-3    | TUBE                          |
| 1           | D3467-5    | SHROUD PLATE                  |
| 2           | D3467-11   | BRACKET                       |
| 1           | D3467-17   | TOP COVER                     |
| 1           | D3467-19   | DOUBLER                       |
| 1           | D3467-20   | DOUBLER                       |
| 4           | NAS1031C3W | NUT PLATE                     |

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| DATE<br><b>06.05.15</b>       |                                | TITLE<br><b>SHROUD ASSEMBLY</b>                          | SCALE<br>1:4            |

**RELEASED**  
06.05.15

**D3467-047 COVER PLATE ASS'Y L/H, SHOWN**  
**D3467-048 COVER PLATE ASS'Y R/H, OPPOSITE**

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**NOTES:**

- 1) WELD PER DART QSI 004
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018  
UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO  
0.010

| QTY<br>-047 | QTY<br>-048 | P/N       | DESCRIPTION               |
|-------------|-------------|-----------|---------------------------|
| X           |             | D3467-047 | COVER PLATE ASSEMBLY, L/H |
|             | X           | D3467-048 | COVER PLATE ASSEMBLY, R/H |
| 1           |             | D3467-1   | COVER PLATE, L/H          |
|             | 1           | D3467-2   | COVER PLATE, R/H          |
| 1           | 1           | D3467-7   | SEAL STRIP                |

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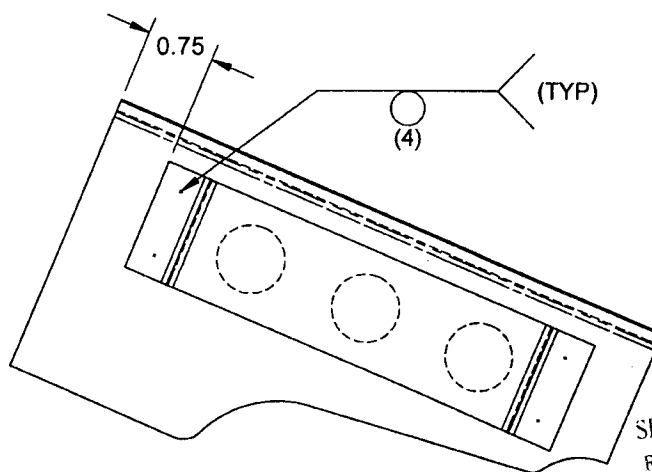
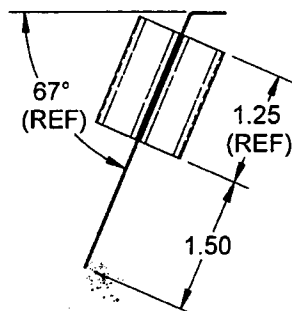
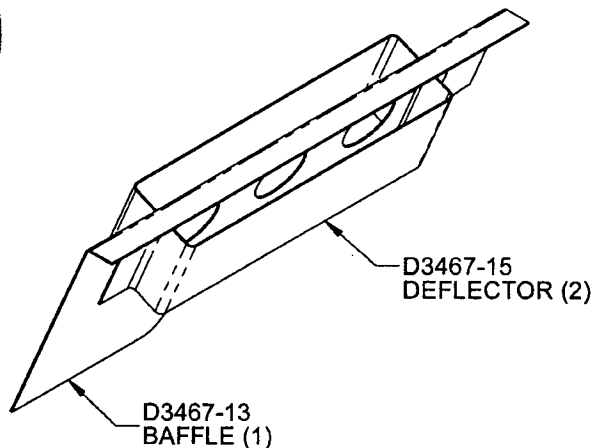
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| DATE<br><b>06.05.15</b>       |                                | TITLE<br><b>SHROUD ASSEMBLY</b>                          | SCALE<br>1:2            |

RELEASED  
*[Stamp]* 06-05-15



**D3467-049 BAFFLE & DEFLECTOR ASSEMBLY**

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**NOTES:**

- 1) SPOT WELD PER DART QSI 004
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018  
UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

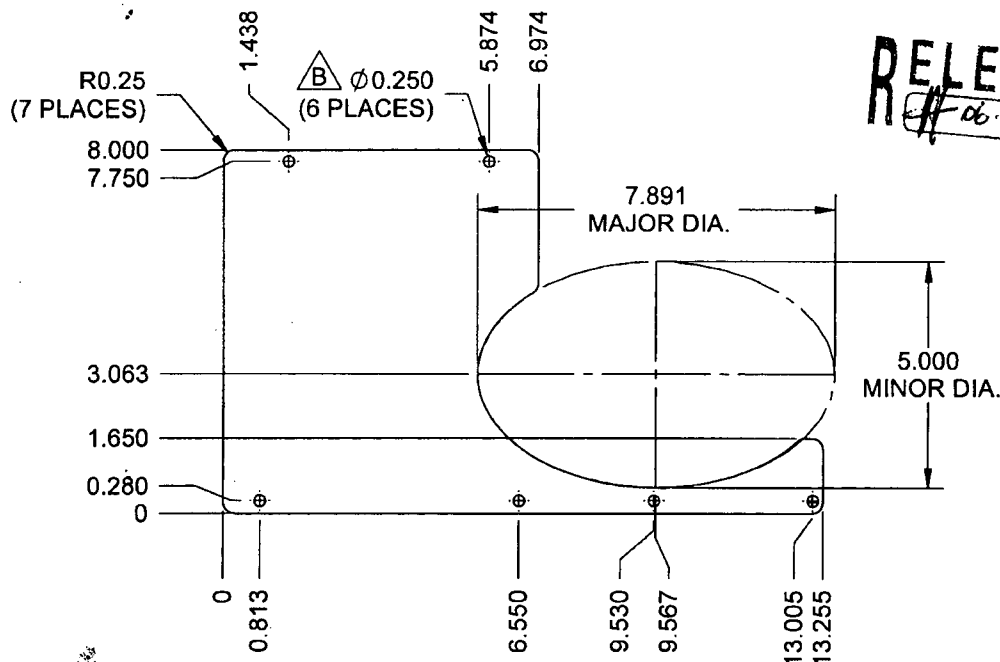
| QTY<br>-049 | P/N       | DESCRIPTION                 |
|-------------|-----------|-----------------------------|
|             | D3467-049 | BAFFLE & DEFLECTOR ASSEMBLY |
| 1           | D3467-13  | BAFFLE                      |
| 2           | D3467-15  | DEFLECTOR                   |

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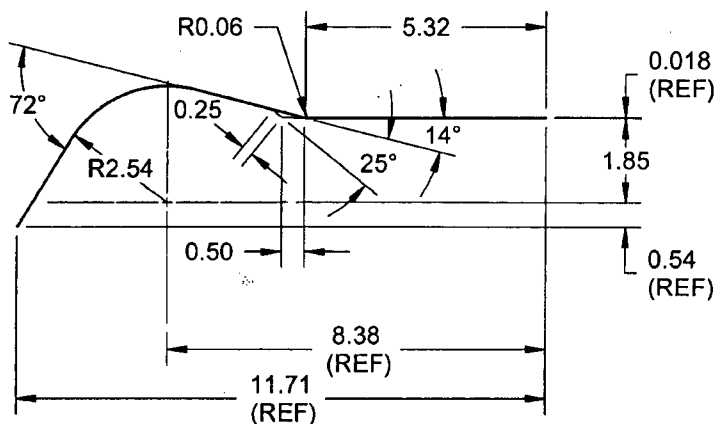
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| DATE<br><b>06.05.15</b> |                | TITLE<br><b>SHROUD ASSEMBLY</b>                          | SCALE<br>1:4            |



**D3467-1F COVER PLATE FLAT PATTERN**



**D3467-1 L/H COVER PLATE  
D3467-2 R/H COVER PLATE (OPPOSITE)**

**D3467-1 L/H COVER  
PLATE ISOMETRIC VIEW,  
D3467-2 R/H COVER  
PLATE (OPPOSITE)**

SCALE 1:8 SHOP COPY

**NOTES:**

- 1) MATERIAL: AISI 304/316 SS SHEET PER MIL-S-5019 (ANNEALED) 2B FINISH  
26 GAUGE SS (0.018 THICK)  
(REF. DART SPEC. M304S26GA)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

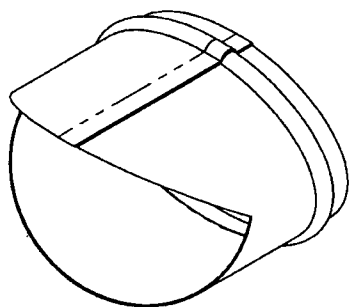
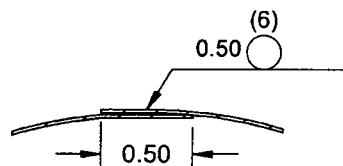
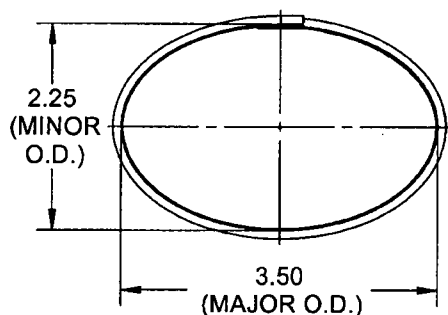
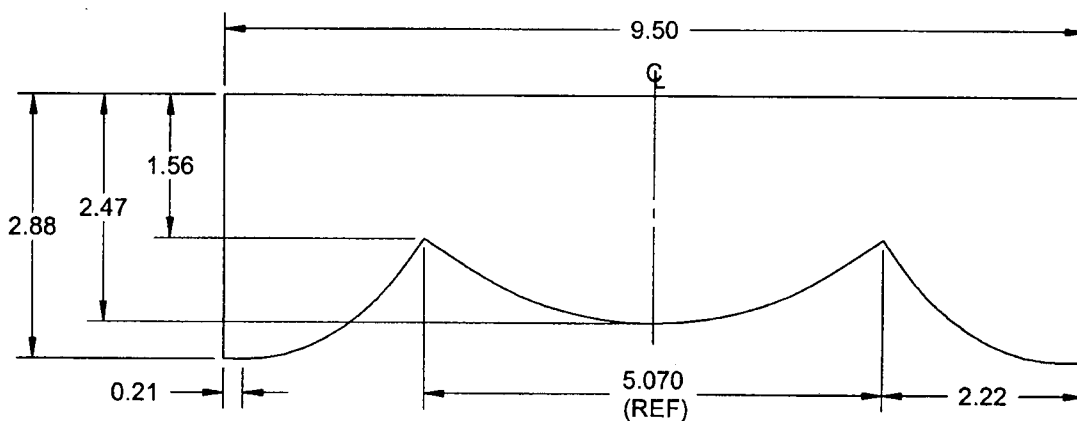
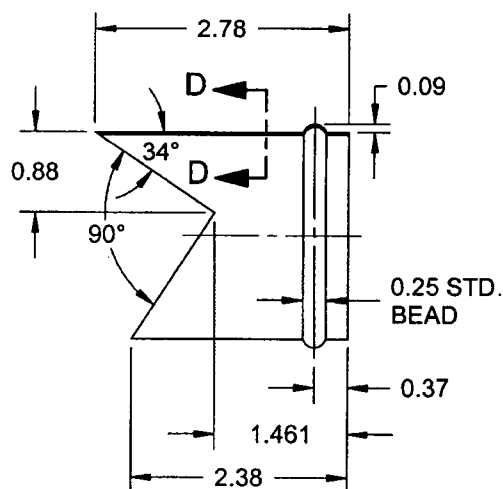
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| CHECKED<br><i>#</i>     | APPROVED<br><i>#</i> | DRAWING NO.<br><b>D3467</b>                              | REV. B<br>SHEET 7 OF 15 |
| DATE<br><b>06.05.15</b> |                      | TITLE<br><b>SHROUD ASSEMBLY</b>                          | SCALE<br>1:2            |

**RELEASED**  
*# 06.05.15***SECTION D-D**  
SCALE 1:1**D3467-3 TUBE DETAIL****D3467-3F TUBE FLAT PATTERN****NOTES:**

- 1) MATERIAL: AISI 304/316 SS SHEET PER MIL-S-5019 (ANNEALED) 2B FINISH  
26 GAUGE SS (0.018 THICK)  
(REF. DART SPEC. M304S26GA)
- 2) FLAT PATTERN IS SYMMETRICAL ABOUT CENTERLINE
- 3) SPOT WELD PER DART QSI 004
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010

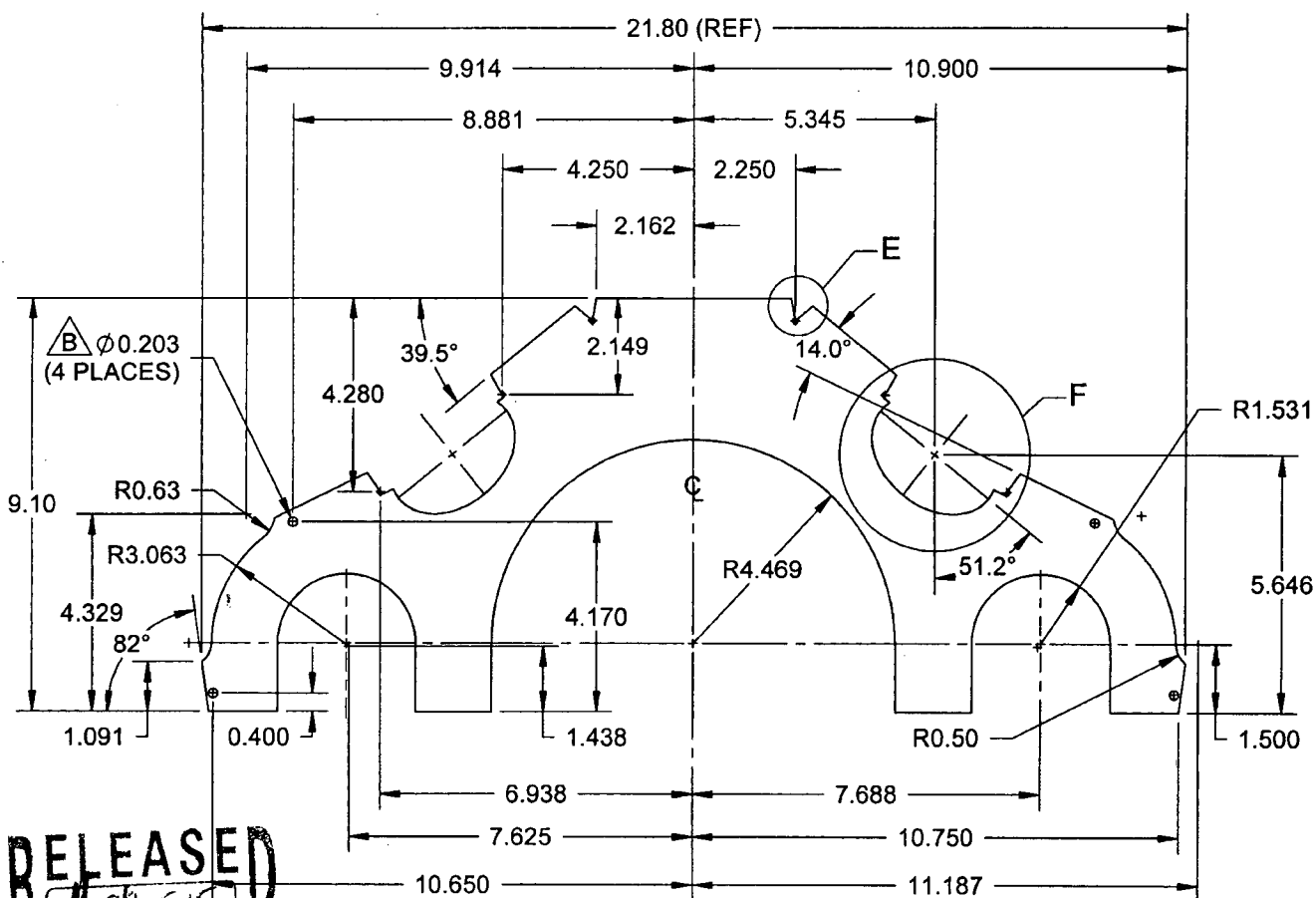
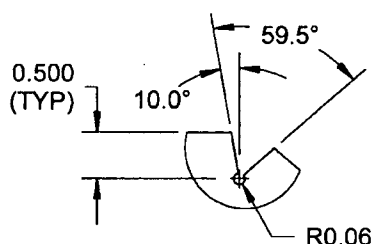
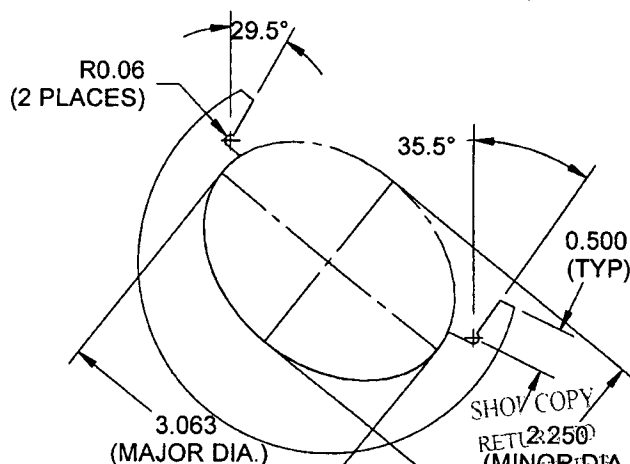
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| DATE<br><b>06.05.15</b> |                      | TITLE<br><b>SHROUD ASSEMBLY</b>                          | SCALE<br>1:8            |

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# 06-05-15**DETAIL E**  
SCALE 1:2**DETAIL F**  
SCALE 1:2  
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28591**D3467-5F AFT PLATE FLAT PATTERN****NOTES:**

- 1) MATERIAL: AISI 304/316 SS SHEET PER MIL-S-5019  
(ANNEALED) 2B FINISH 26 GAUGE SS (0.018 THICK)  
(REF. DART SPEC. M304S26GA)
- 2) PART IS SYMMETRICAL ABOUT CENTERLINE
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010

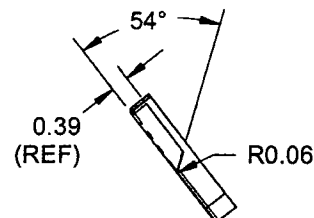
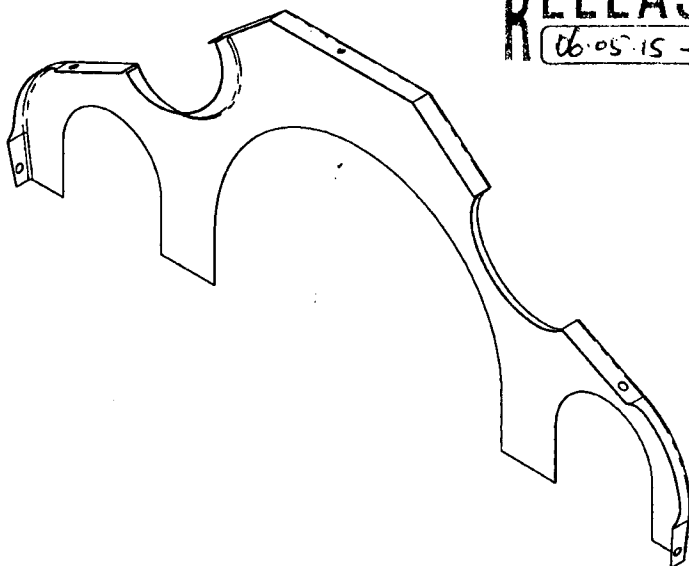
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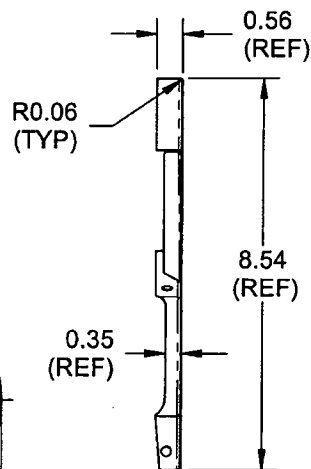
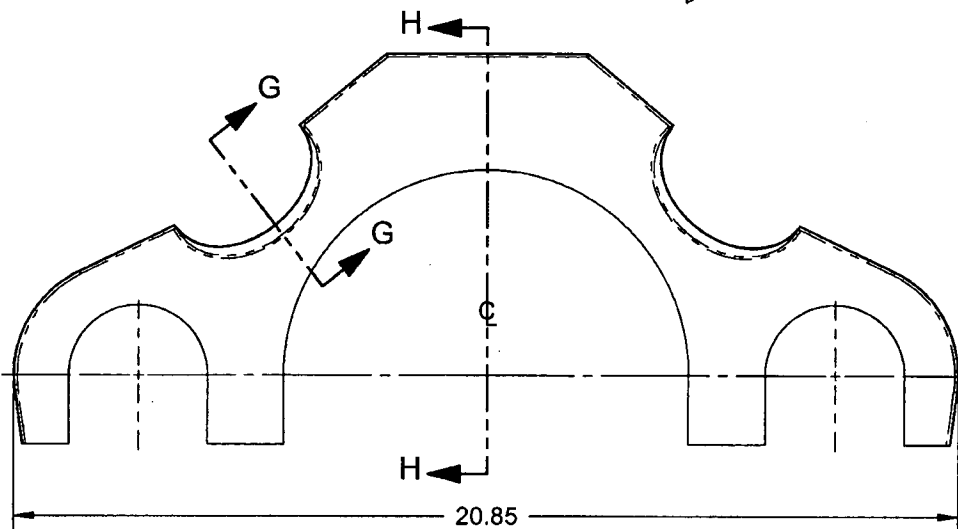
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| DATE<br><b>06.05.15</b> |                  | TITLE<br><b>SHROUD ASSEMBLY</b>                          | SCALE<br>1:4            |

**RELEASED**  
06.05.15



**SECTION G-G**



**SECTION H-H**

**D3467-5 AFT PLATE BENDING DETAIL**

**NOTES:**

- 1) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 2) ALL DIMENSIONS ARE IN INCHES
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.010

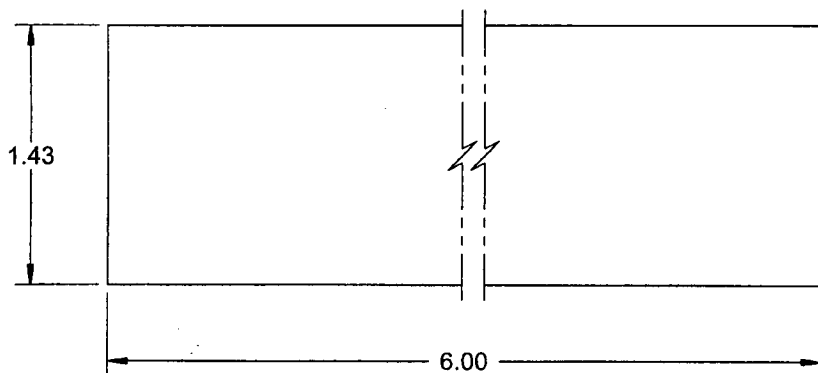
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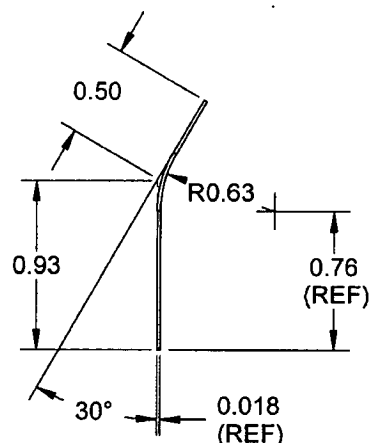
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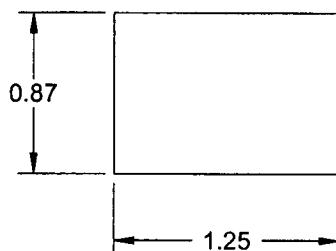
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| DATE<br><b>06.05.15</b>       |                                | TITLE<br><b>SHROUD ASSEMBLY</b>                          | SCALE<br>1:1             |

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*[Stamp]*

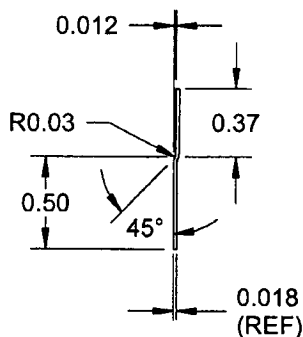
**D3467-7F SEAL STRIP**  
**FLAT PATTERN**



**D3467-7 SEAL STRIP**  
**BENDING DETAIL**



**D3467-11F BRACKET**  
**FLAT PATTERN**



**D3467-11 BRACKET**  
**JOGGLE DETAIL**

**NOTES:**

- 1) MATERIAL: AISI 304/316 SS SHEET PER MIL-S-5019 (ANNEALED) 2B FINISH  
26 GAUGE SS (0.018 THICK)  
(REF. DART SPEC. M304S26GA)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

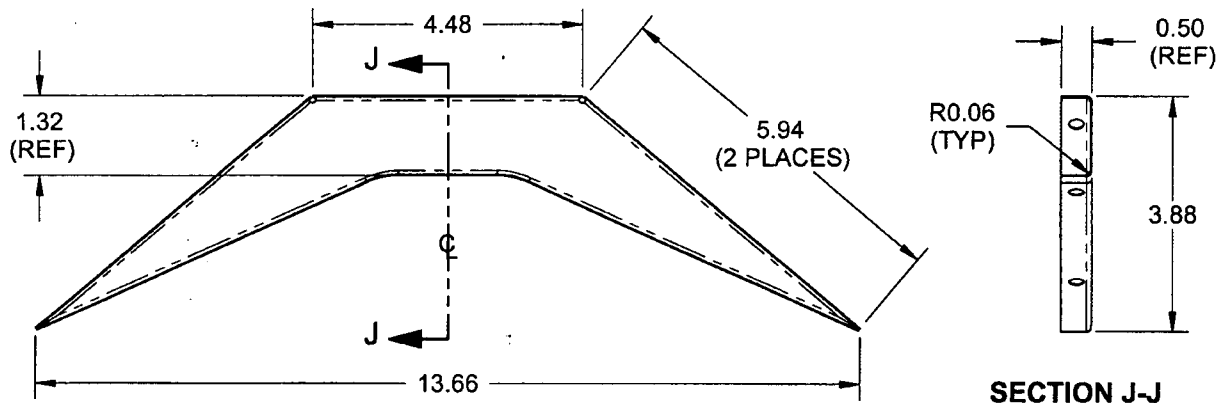
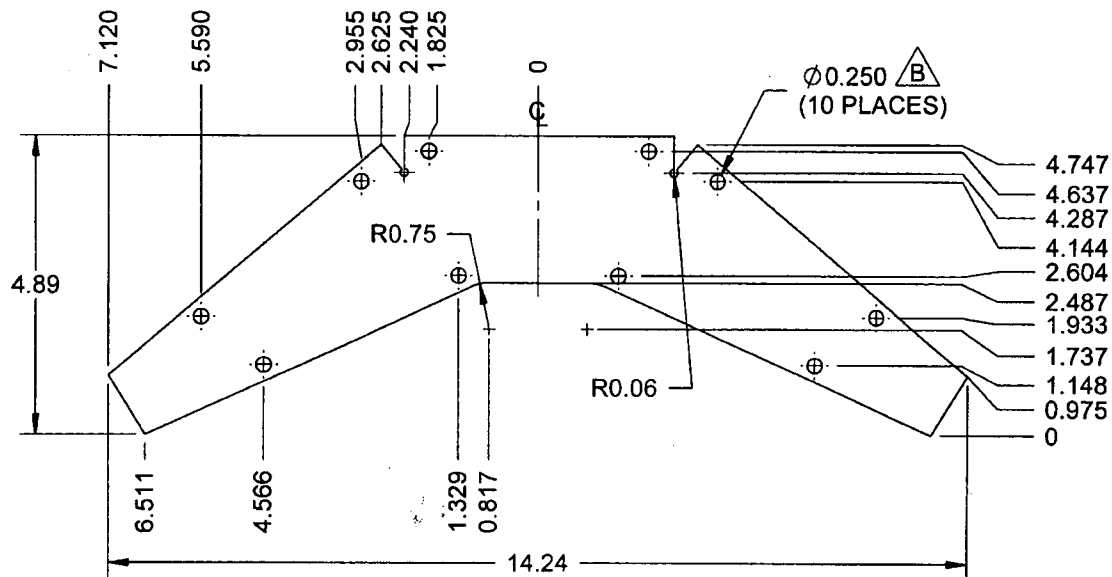
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| DATE<br><b>06.05.15</b> | TITLE<br><b>SHROUD ASSEMBLY</b> |  | SCALE<br>1:3             |

**RELEASED**  
*06.05.15***D3467-9 FWD PLATE BENDING DETAIL****D3467-9F FWD PLATE FLAT PATTERN****NOTES:**

- 1) MATERIAL: AISI 304/316 SS SHEET PER MIL-S-5019 (ANNEALED) 26 GAUGE SS (0.018 THICK)  
(REF. DART SPEC. M304S26GA)
- 2) PART IS SYMMETRICAL ABOUT CENTER LINE
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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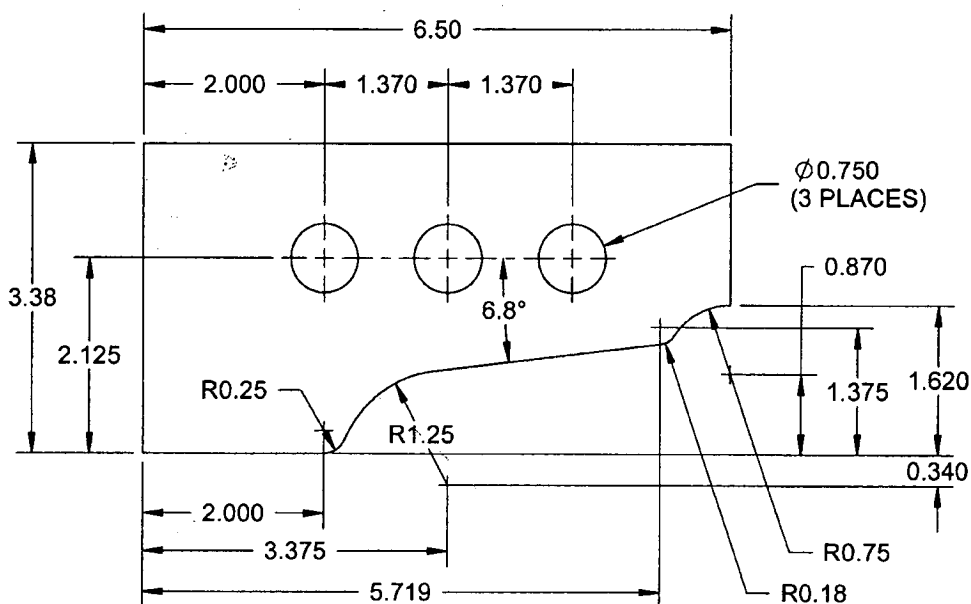
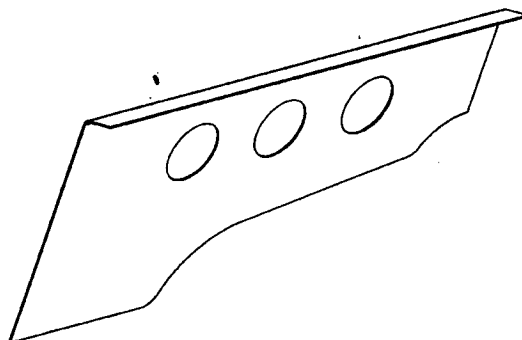
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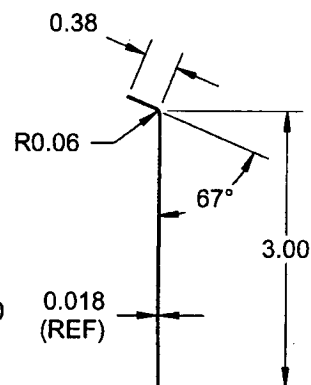


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| DATE<br><b>06.05.15</b> |                 | TITLE<br><b>SHROUD ASSEMBLY</b>                          | SCALE<br>1:2             |

RELEASED  
#06.05.15



**D3467-13F BAFFLE  
FLAT PATTERN**



**D3467-13 BAFFLE  
BEND DETAIL**

**NOTES:**

- 1) MATERIAL: AISI 304/316 SS SHEET PER MIL-S-5019 (ANNEALED) 2B FINISH  
26 GAUGE SS (0.018 THICK)  
(REF. DART SPEC. M304S26GA)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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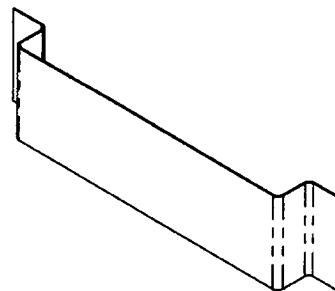
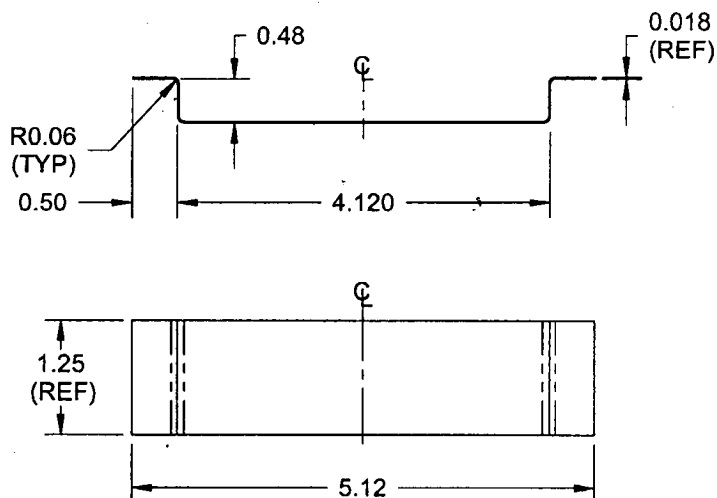
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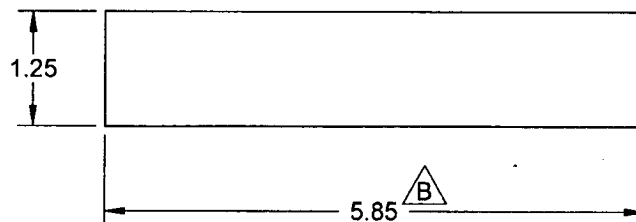


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*[Stamp]*



### D3467-15 DEFLECTOR BENDING DETAIL



### D3467-15F DEFLECTOR FLAT PATTERN

#### NOTES:

- 1) MATERIAL: AISI 304/316 SS SHEET PER MIL-S-5019 (ANNEALED) 2B FINISH  
26 GAUGE SS (0.018 THICK)  
(REF. DART SPEC. M304S26GA)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

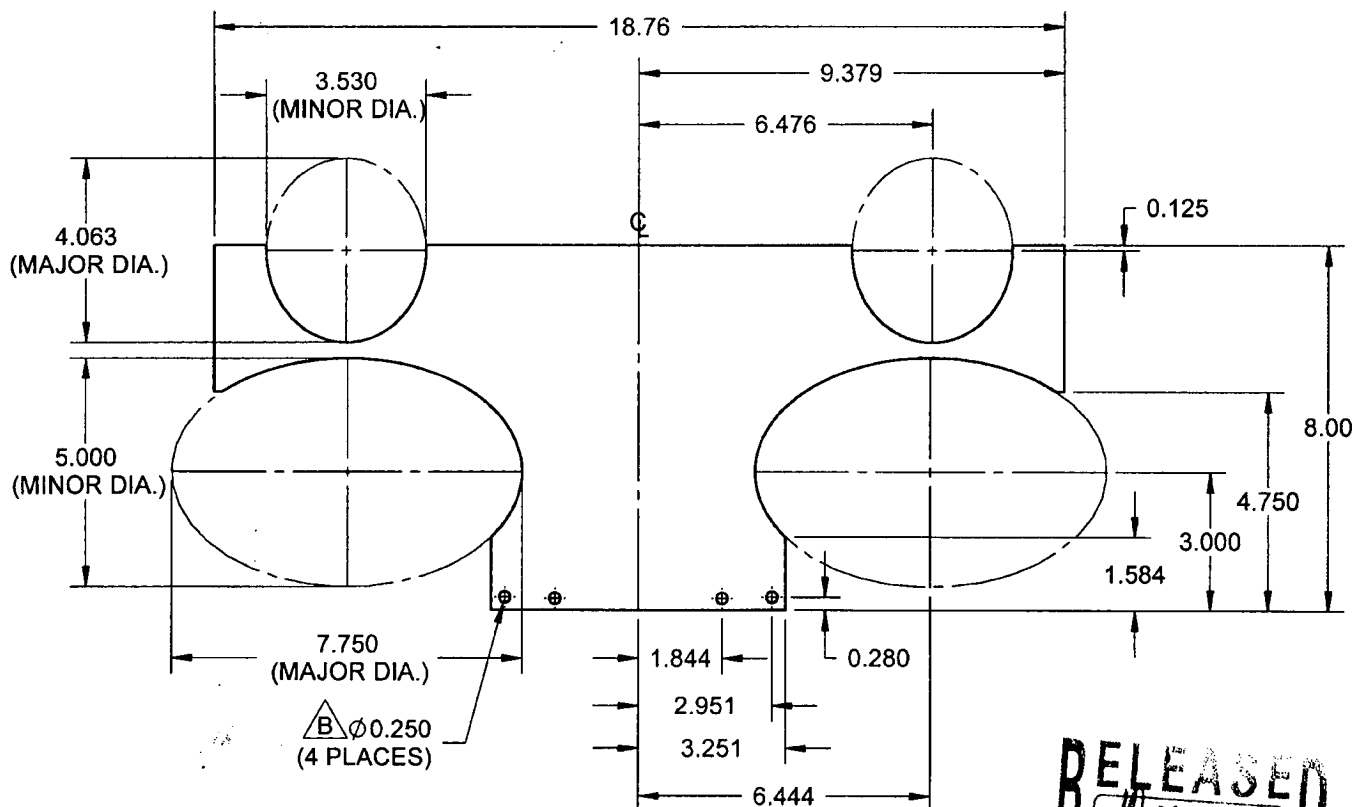
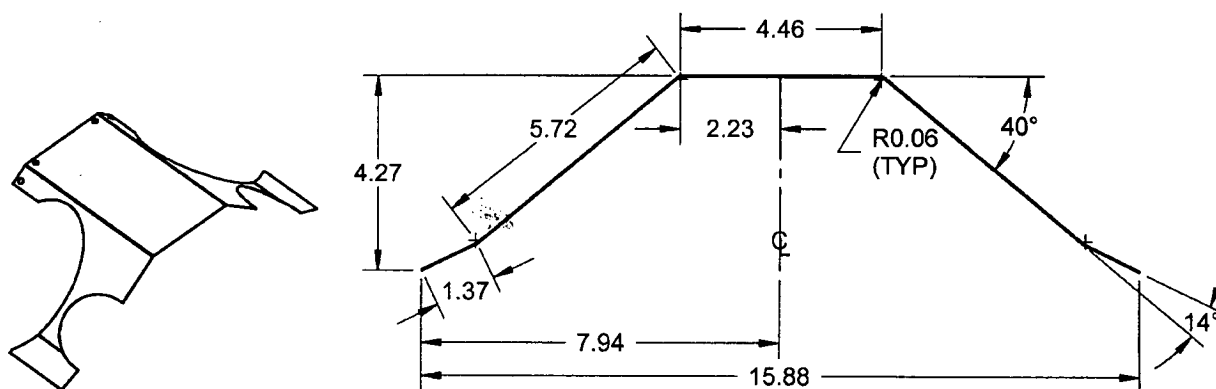
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| DATE<br><b>06.05.15</b> | TITLE<br><b>SHROUD ASSEMBLY</b> |  | SCALE<br>1:4             |

**D3467-17F TOP COVER FLAT PATTERN****RELEASED**  
#06-05-15**D3467-17 TOP COVER BENDING DETAIL****NOTES:**

- 1) MATERIAL: AISI 304/316 SS SHEET PER MIL-S-5019 (ANNEALED) 2B FINISH  
26 GAUGE SS (0.018 THICK)  
(REF. DART SPEC. M304S26GA)
- 2) FINISH: NONE
- 3) PART IS SYMMETRICAL ABOUT CENTERLINE
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010

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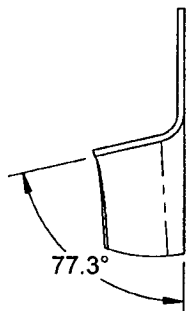
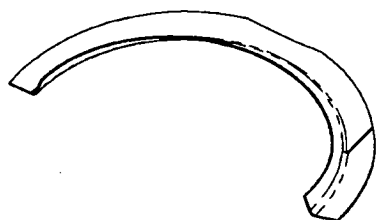
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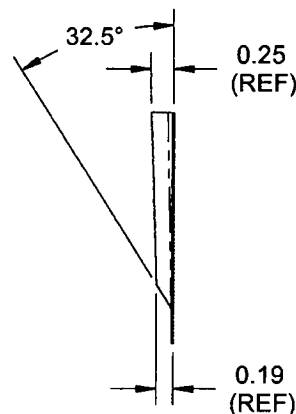
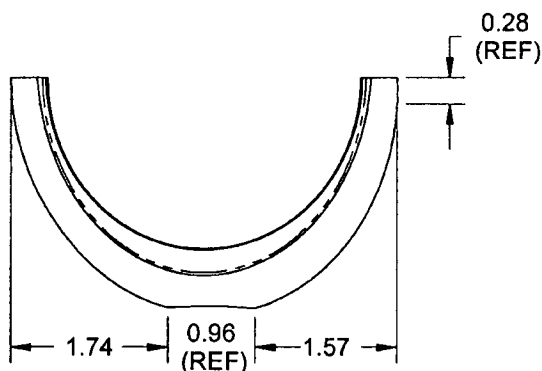
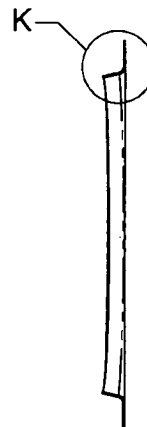


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| DATE<br><b>06.05.15</b> |                      | TITLE<br><b>SHROUD ASSEMBLY</b>                          | SCALE<br>1:2             |

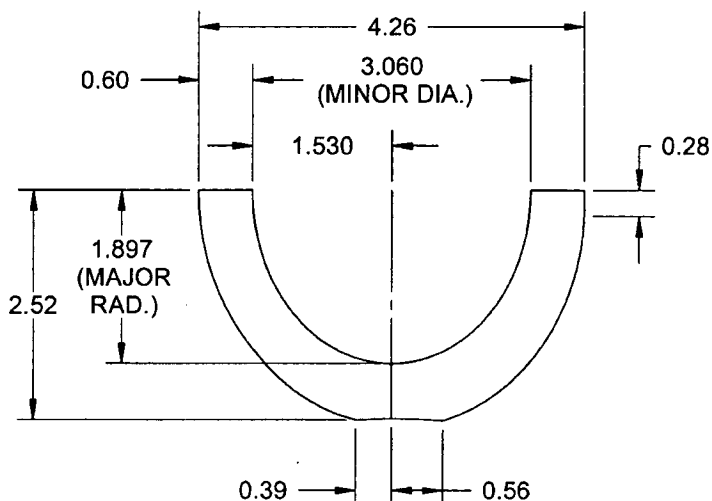
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*06.05.15*



**DETAIL K**  
SCALE 1:2



**D3467-19 DOUBLER, L/H SHOWN**  
**D3467-20 DOUBLER, R/H OPPOSITE**



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**D3467-19F FLAT PATTERN**

**NOTES:**

- 1) MATERIAL: AISI 304/316 SS SHEET PER MIL-S-5019 (ANNEALED) 2B FINISH 26 GAUGE SS (0.018 THICK) (REF. DART SPEC. M304S26GA)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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